

Date: Thursday, 05/02/2009 3:47:16 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	CLEVIS
<b>Job Number</b> :	45564		
<b>Estimate Number</b> :	12498		
<b>P.O. Number</b> :		<b>Part Number</b> :	D351613
<b>This Issue</b> :	05/02/2009	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3516 REVC
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	37620	<b>Drawing Revision</b> :	C
<b>Written By</b> :		<b>Material</b> :	
<b>Checked &amp; Approved By</b> :	<u>JUD 09.02.04</u>	<b>Due Date</b> :	03/03/2009
<b>Comment</b> :	Est Rev:A New Issue 06-06-09 JLM Est Rev:B chg to revC ecn1136 08-03-18 DD verified by:		

Qty: 20 Um: Each

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304S11GA	304/316 0.125 Sheet
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**Comment:** Qty.: 0.0218 sf(s)/Unit Total : 0.4368 sf(s)  
 304/316 .125 Sheet 11GA  
 (M304S11GA)  
 Batch: 109358 B9-29

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D3516  
 Dwg Rev: C B9-29  
 Prog Rev: C

2-Deburr if necessary

M/L

09/02/10

43x

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



**Comment:** SECOND CHECK

8 09/02/10 43x counters

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1  
 Form as per Dwg D3516

SB 09/02/18 43

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 05/02/2009 3:47:16 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 45564

Part Number: D351613

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



*Force 19*



Comment: INSPECT WORK TO CURRENT STEP

*(43) counted*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Basket cell*

*mk 09/02/19*

*(43)*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



*09/02/2019*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*mk 09-02-19*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

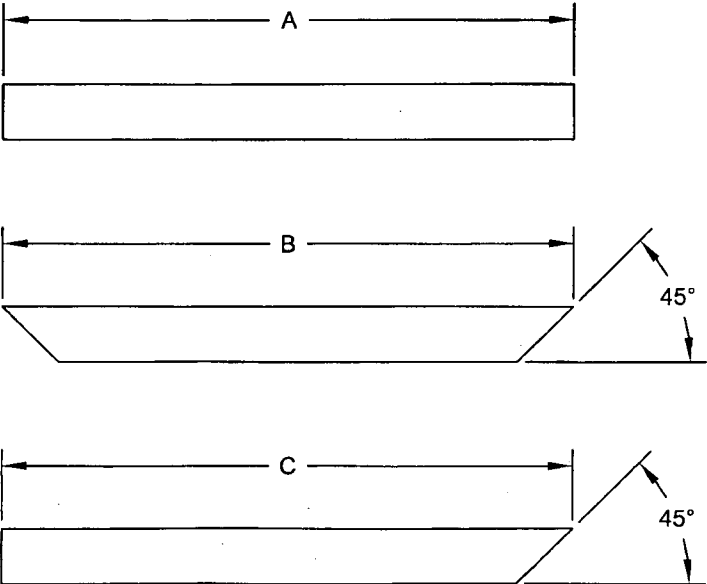
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



PARTS LIST FOR D3516-041 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	LENGTH C	DESCRIPTION
D2232-3	2	N/A	N/A	N/A	HINGE PLATE
D2327-3	2	N/A	N/A	N/A	BUSHING
D2581	2	N/A	N/A	N/A	MOUNTING BRACKET
D3442-1	2	N/A	N/A	N/A	SHIM
D3516-1	2	—	102.00	—	RIB
D3516-3	2	—	—	2.70	RIB
D3516-5	8	26.75	—	—	RIB
D3516-7	3	45.50	—	—	RIB
D3516-9	4	N/A	N/A	N/A	RIB (MAKE FROM D2235-3)
D3516-11	6	N/A	N/A	N/A	CLEVIS
D3516-13	4	N/A	N/A	N/A	CLEVIS
D3516-15	2	—	—	19.32	RIB
D3725-1	2	N/A	N/A	N/A	HOOP



D3516-041 BASKET BASE ASSEMBLY NOTES:

- 1) MATERIAL:  
FRAME - AISI 304/316 STAINLESS STEEL SQUARE TUBING, 3/4 X 3/4 0.065 WALL  
(REF. DART SPEC. M304TS0.750W.065)  
MESH - 3/4-16F EXPANDED STAINLESS STEEL  
(REF. DART SPEC. M304EX0.75-16F)
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 75 lbs
- 8) WELDING: PER DART QSI 004

C	ADD D3725-1 (ZNA7-3) AND D3516-15 (ZNA5-3), QTY.(1) PER END OF BASKET BASE; SHORTEN D3516-3 (REF. ECN#1136); REASON: CUSTOMER REQUEST	MB	08.02.20
B	ADD QTY.(4) D3516-13; QTY.(6) D3516-11 WAS QTY.(1) SEE TR-D119-756-1 REV. A	MB	06.07.25
A	NEW ISSUE	MB	06.06.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.02.20		

DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D3516

REV. C

SHEET 1 OF 4

TITLE

BASKET BASE ASSEMBLY

SCALE

NTS

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8

7

6

5

4

3

2

1

D

C

B

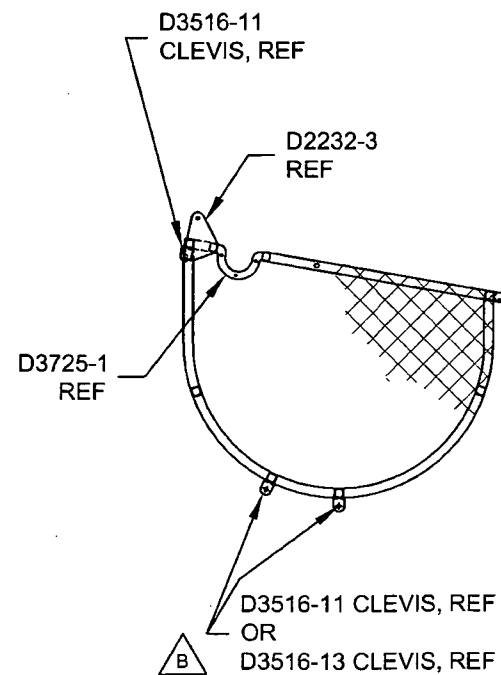
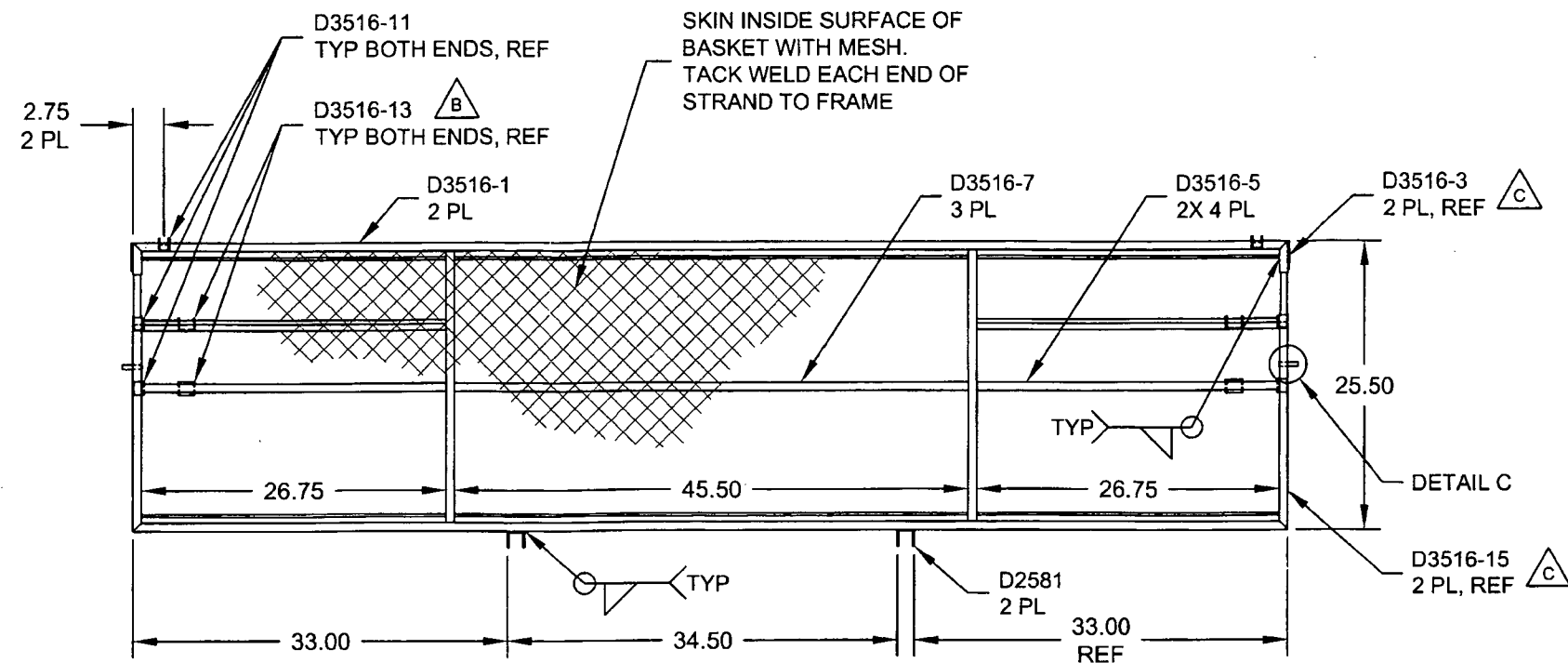
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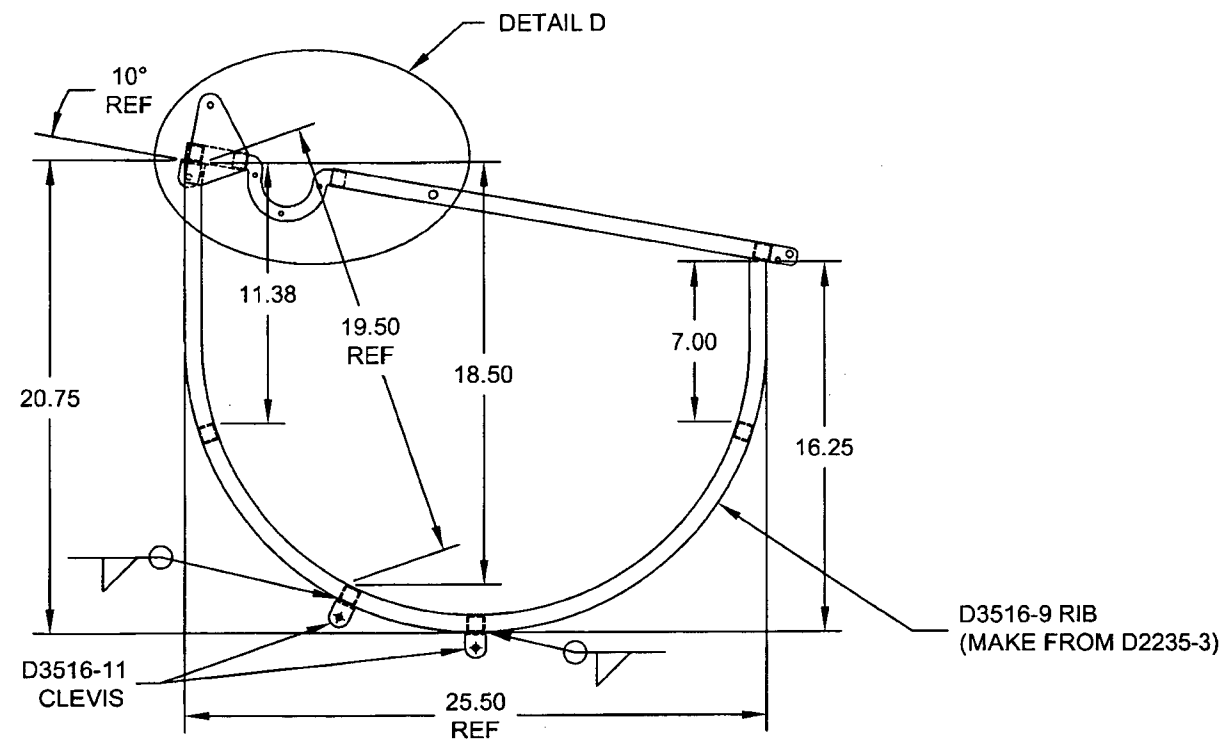
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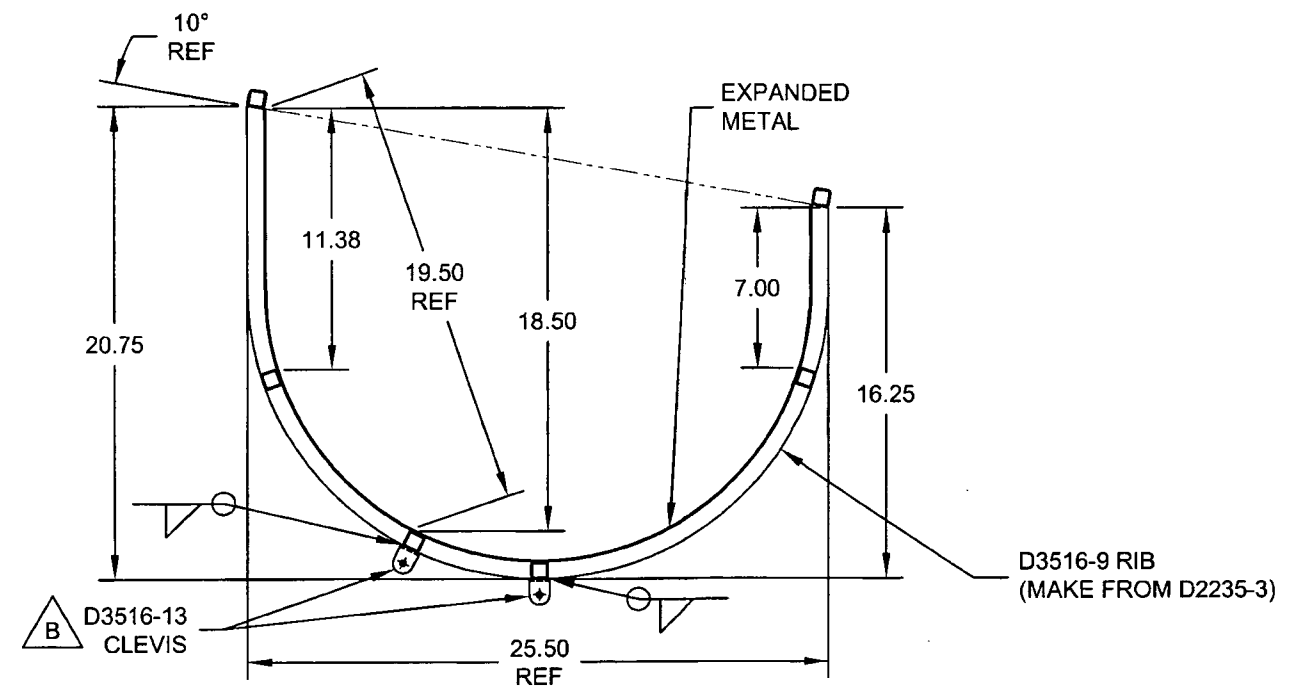
### D3516-041 BASKET BASE ASSEMBLY

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MFG. APPR.		D3516	SHEET 2 OF 4
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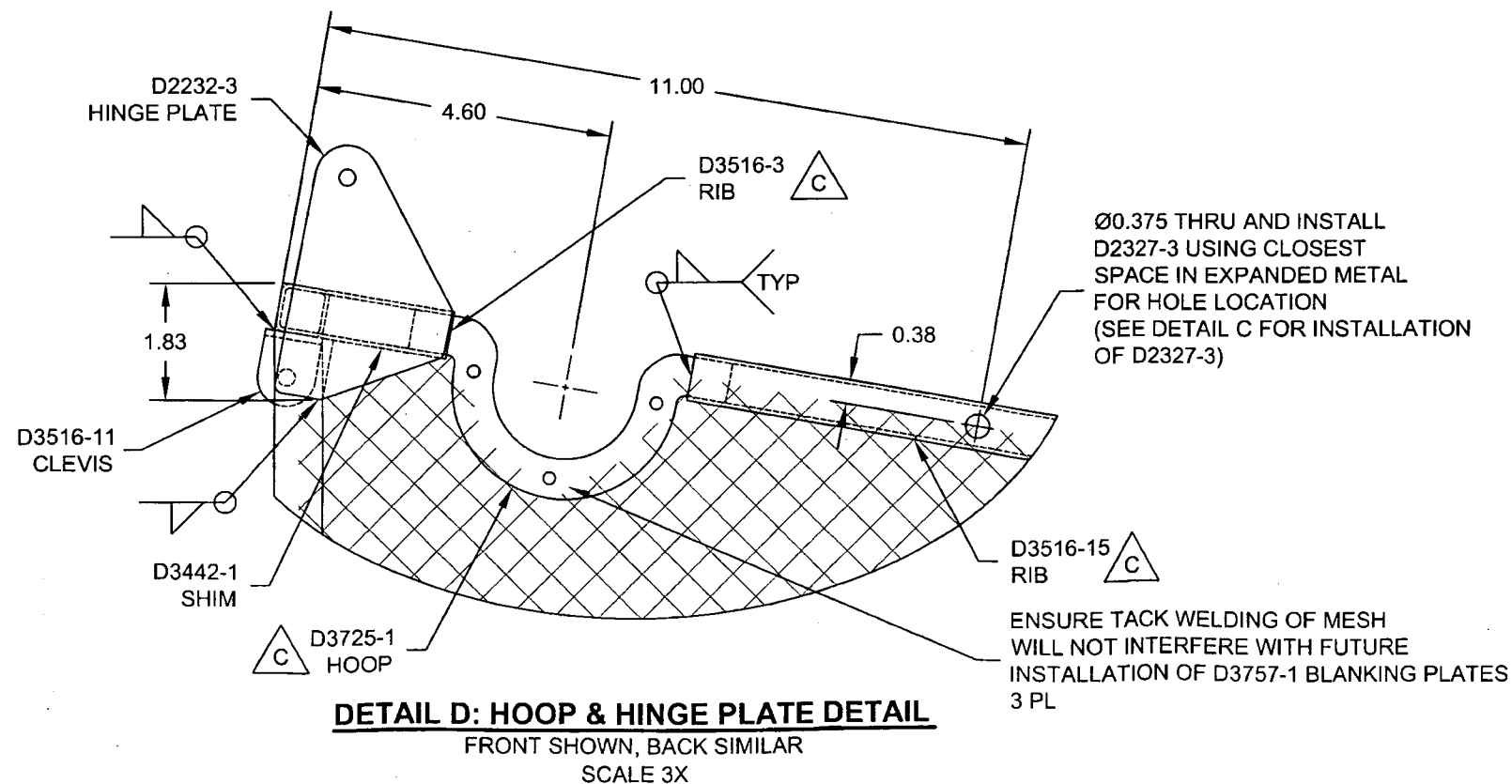
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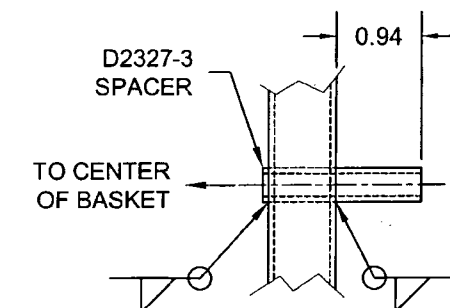
**SECTION A-A: END RIB DETAIL**  
(MESH NOT SHOWN FOR CLARITY)  
TYP BOTH ENDS



**SECTION B-B: CENTER RIB DETAIL**  
2 PL



**DETAIL D: HOOP & HINGE PLATE DETAIL**  
FRONT SHOWN, BACK SIMILAR  
SCALE 3X

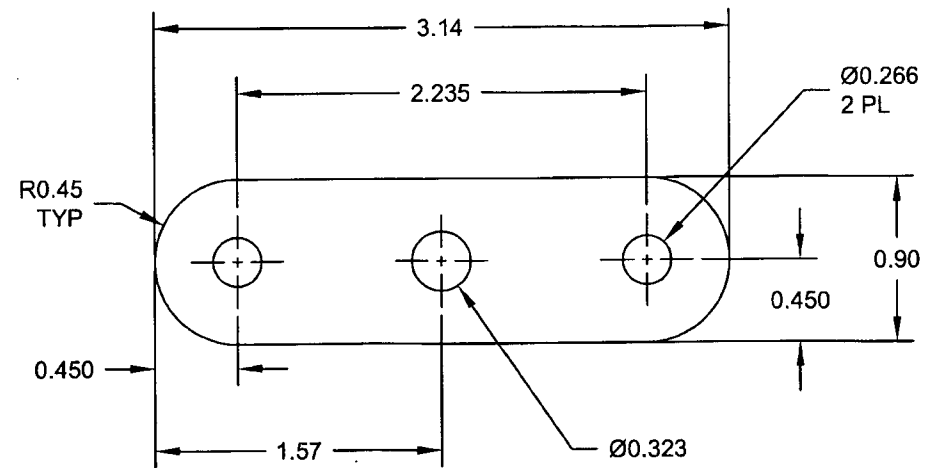


**DETAIL C: SPACER INSTALLATION**  
SCALE 4X

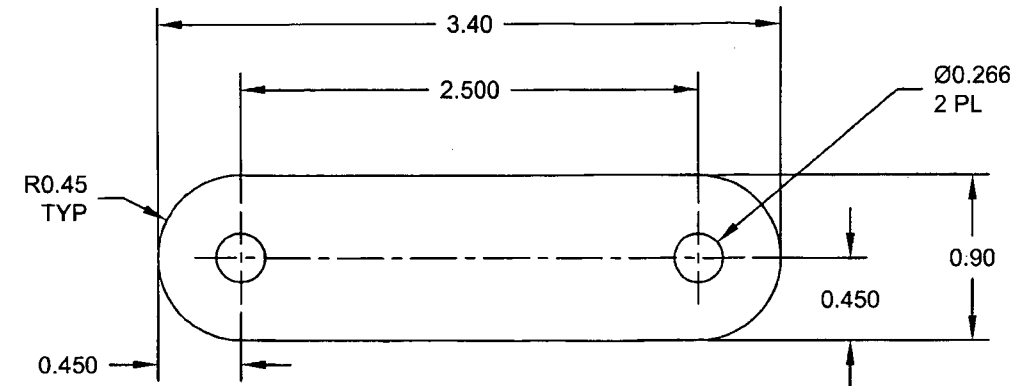
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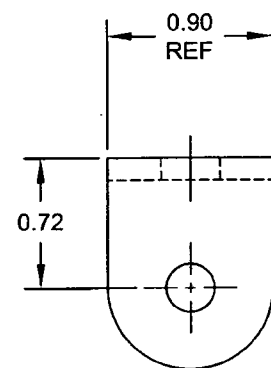




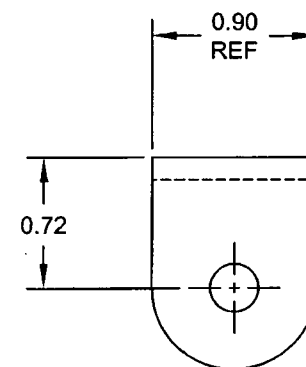
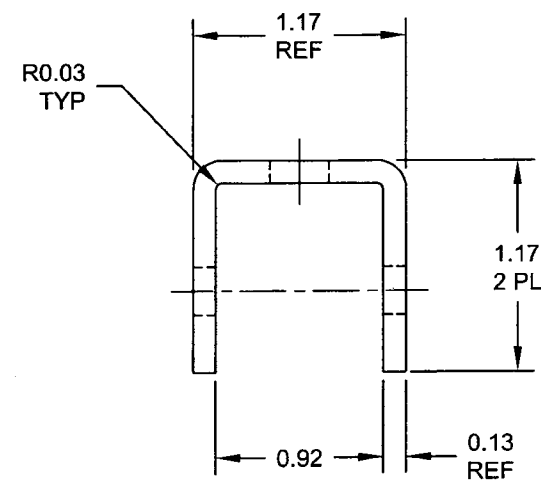
1 D3516-11F CLEVIS FLAT PATTERN



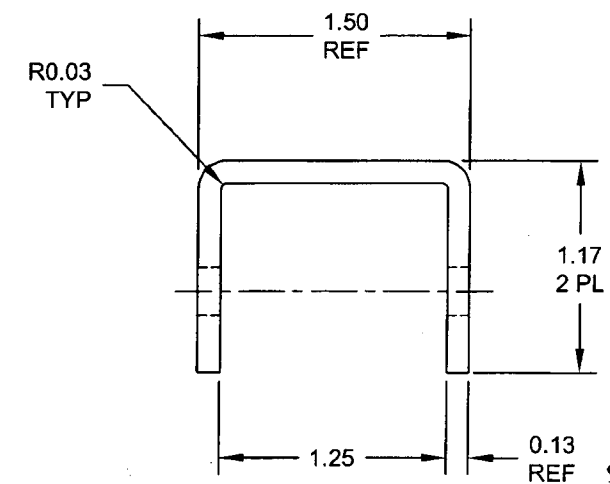
1 D3516-13F CLEVIS FLAT PATTERN



D3516-11 CLEVIS BENDING DETAIL  
(MAKE FROM D3516-11F)



D3516-13 CLEVIS BENDING DETAIL  
(MAKE FROM D3516-13F)



**D3516-11/-13 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR AMS 5524, 11 GAUGE (0.125 THICK)  
(REF. DART SPEC. M304S11GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3516-11 = 0.09 lbs  
D3516-13 = 0.10 lbs

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